January-02-13 1:53:15 PM

Item ID: D3200-3  Revision ID:  Item Name: Door Wedge				Accept	*N	19000	140	100	)* se	etup Star Stop	14.71		
Start Date: Required Date: Reference:	1/02/13 1/11/13	<b>Start Qty:</b> 12.00 <b>Req'd Qty:</b> 12.00	*12* *12*			Cust Item ID Customer:	<b>:</b>						
Approvals:		in:		Tooling: SPC (Y/N):			e:		R	un Star Stop	1/1	R1* R2*	
Sequence ID/ Work Center II	D .	Operation Description		Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr							The state of the s				
D3200	Rev	A											
*100 *100* Bandsaw Jeaspa Bandsaw		BAND SAW  Memo  Cut blank: 1	.000 X 1.970"	0.00	Po	13-01	- 22_		12	Ø	,		-
*110 *110* HAAS I HAAS CNC vertice	al machine #1	HAAS CNC VERTICAL  Memo 1-Machine I	. MACHINING #1 D3200-3 as per Folio FA33	0.00 0.00 7 and Dwg D32002-1	P0 Deburr	13.01	-22		12	Ø			_
120 *120* QC Quality Control		QC2- Inspect parts off m	achine FAI/FAIB	0.00	Po	13-01	-22		12	Ø			

NCR:	· · · · · · · · · · · · · · · · · · ·												
_											QA Closed:	Date	
Work Orde	er:					DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	
Part No						Scrap Machining Small F Use-as-is Thermoforming Finishi			Crosstube Small Fab Finishing Composite	Pro Rec/Sto	Engineering Quality Other		
Root		_				ption of work order update	- 1	Initial	Act		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	T CATE	GORY				
Landi		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection	Crimped. t n Strip in		D/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misreac	ori Incomplete ions Incomplete/Unance iled	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
ī i	1	Rinnles in	Rend		į.	Drill Holes	1	Offcet					

Out of Calibration

Out of Sequence

Outside Dimensions

Date:

DQA:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

lanuary-02-13	1:53:15 PM		<u></u>									
Revision ID:	D3200-3  Door Wedge			Accept	*[	N900	040	100	<b>)*</b> s	etup Star Stop	1/1	S1* S2*
	1/02/13	<b>Start Qty:</b> 12.00 <b>Req'd Qty:</b> 12.00	*12 *12			Cust Item II	D:					
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):			nte:		R	kun Star Sto <sub>l</sub>	, "IVI	R1* R2*
Sequence ID/ Work Center II	)	Operation Description QC8- Inspect parts - secon	d check	Set Up/ Run Hours	0	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*130* QC Quality Control		Memo	u check	0.00	D.A	13/01/2	13		12	<u>Ø</u>		08
140 <b>*111</b>		Identify as per dwg & Stor	ck Location:	0.00						(13/6)	1/27	(12)
Packaging		QC21- Final Inspection -	Work Order Palance	0.00						,	1	~ <i>l</i> /\
*150 *150* QC Quality Control		Memo	work Order Release	0.00						13/1	128	D.

NB-01-28

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
		OA Closed:	Date:	

										QA Closed.	Date	·
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N	0.				Rework Scrap Use-as-is	T.	Skid-tube Crosstub  Machining Small Fa			Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other
NCR N	NCR No.				Work Order Update	''	Thermoforming Finishi  Large Fab Composi			Rec/Stor	Supplier	J Other
Root				Descri	ption of work order update	Initia	al	Act	ion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief I	Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling												
Operator												
Material												
Setup 30	_											
Other			1									
Process												
Supplier	_											
Training												
Unapproved		<u> </u>										1
	<u>-</u>					AULT C	ATEC	GORY			· · · · · · · · · · · · · · · · · · ·	
Landin	<del></del>	•			General					1	_	_
-	Bending				Bend	Gra				Ovalized	_	Pressure/Forced
	Centre No	ot Concer	ntric to	o/s	BOM/Route	${f H}$	rdwa		<u> </u>	Over/Under	<b>⊢</b>	Temperature/Cure
-	Cracks			<u> </u>	Broken/Damaged	⊢ :		ori Incomplete		Part Incorred		Weld
Ļ	Crushed/	Crimped.			Burrs	$\vdash$		ons incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
<u> </u> _	Cuffs			<u> </u>	Contamination	$\vdash$		nance		Part Moved		
L	Heat Trea			L	Countersink	$\vdash$	slabe			Positioned V		
_	Inspection	•	Tube		Cut Too Short	<del></del>	sread			Power Loss/	Surge	Other
L	Ripples in				Drill Holes	Off						
Ĺ	Torque W			۱	Drawing	——		alibration				
L	Turning S	equence			Finish	Out	t of S	equence				
	Wave/Tw	ist in Tub	e		Folio	Out	tside	Dimensions				

Page 1

Work Order ID:

95109

Parent Item:

D3200-3

Parent Item Name:

Door Wedge

**Start Date: 1/02/13** 

Required Date: 1/11/13

Start Qty: 12.00

× .19

Required Qty: 12.00

Comments:	IPP Rev:A Remo	ved from 9 Digit	06-01-25	5 JLM									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No			100	sf	296.4950	0.015	0.189474	_P0_	13~	01-22
				Location		Loc Qty	Lo	c Code					
				MAT019		296.4949895							
				12	1278	12.0949895							
				12	2575	47.6							
				12	3229	53							
				12	3704	63.8							

120

123949

122722

											DQA:	Dat	e:	
NCR: Y	es /	No				WORK ORDER NON-	CON	FORM	MANCE / UPI	DATE	QA Closed:	 Dat	e:	
Work Orde	er:			-		DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part N	Part No					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstu Machining Small F Thermoforming Finishi Large Fab Composi			<b>→</b>	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other	
Root Cause	D	ate	Step	Qty	l	ption of work order update or Non-conformance	- 1	nitial ef Eng		tion ription	Sign & Date	Verification	n QC Inspect	tor
oc/Data quip/Tooling Operator Material etup Other Process upplier Training														
						F	AUL	CATE	GORY					
Landir	Cen	ks	t Concer Crimped.	ntric to	o/s	General Bend BOM/Route Broken/Damaged Burrs			re on Incomplete ions Incomplete/l	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi	ct	Pressure/Force Temperature/C Weld Wrong Stock Pu	ure
	Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend			Contamination Countersink Cut Too Short Drill Holes		Maintenance Mislabeled Misread Offset			Part Moved Positioned V Power Loss/		Other			
		•	aves in E equence	xtrusio	n	Drawing Finish	-		Calibration Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	95109
Description: Door Wedge	Part Number:	D3200-3
Inspection Dwg: D3200 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005/-0.000	.197	~		VERN	PHD-21
0.405 x 100°	+/-0.010	<sub>405</sub>	/		4.6	, ,
0.500	+/-0.010	. 499	/		14	11
1.722	+/-0.010	1 723	1		7.	14
0.380	+/-0.010	.380	1		3.	1.
0.975	+/-0.010	.975			١,	11
0.750	+/-0.030	. 747	/		) i	11
0.015 - 0.050	N/A	. 640	1		11	11
	·					
	,	· · · · · · · · · · · · · · · · · · ·				

Measured by: 20	Audited by: b. 08	Prototype Approval:	N/A
Date: 13-01-22	Date: 13/01/23 9-89	Date:	N/A

Rev	Date	Change	Revised	Approved
Α	03.11.12	New Issue P/O D412-698-015	KJ/RF ♂	74

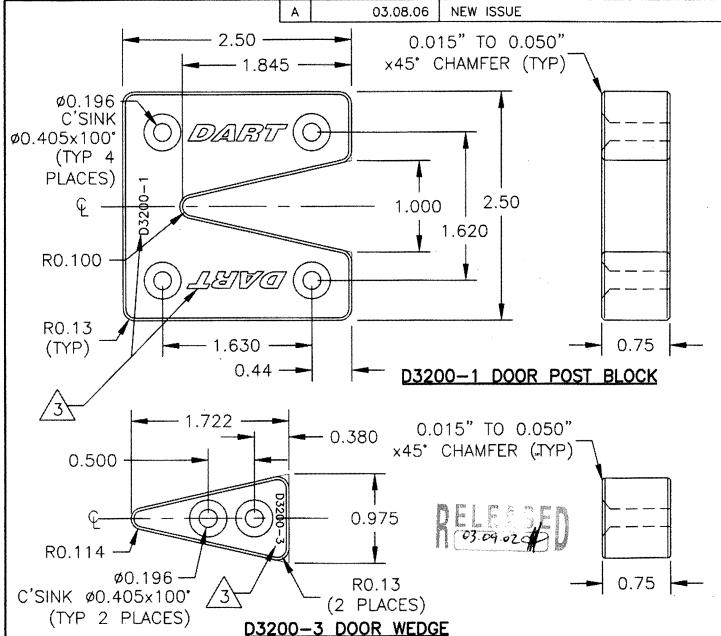
95109

pl 13-01-4





	DESIGN (1)		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
	CHECKED N		APPROVED	DRAWING NO.		REV. A		Ā
		4	#	D3200		SHEET	1 OF	1
-	DATE	······································	<u> </u>	TITLE			SCAL	E
	03.08.06		DOOR WEDGE			1:	:1	
	Δ		03.08.06	NEW ISSUE				



## D3200-1/-3

- MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- PARTS ARE SYMMETRIC ABOUT CENTERLINE
- ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- BREAK ALL SHARP EDGES 0.005 TO 0.010
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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